

Date: Tuesday, 14/04/2009 9:07:38 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 350 SKIDTUBE EXTRUSION (BENT)		
Job Number	: 47133			Part Number	: D26003BENT		
Estimate Number	: 10997			Drawing Number	: D2600 D1/D2750 F		
P.O. Number	:			Project Number	: N/A		
This Issue	: 14/04/2009	S.O. No.	:	Drawing Revision	: D1/F		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SKIDTUBES	Due Date	: 21/04/2009	Qty:	18 Um: Each
Previous Run	: 45897						
Written By	:						
Checked & Approved By	: <u>MEL 09-04-14</u>						
Comment	: Est. B02.11.28 Reformat KJ Est Rev:C 08-09-30 D2750 revF as per dwg DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26003120	Extrusion Round 3" 350	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s) Extrusion Bent			
Pick: Qty Part Number Description Batch 1 D2600-3 Extrusion <u>43960</u>			
2.0	BENDING	BENDING MACHINE - SKIDTUBES	
Comment: BENDING MACHINE Deburr one end of extrusion Drill #30 pilot holes using DT8689 Open holes to 5/16" and deburr Bend using CNC bending machine as per program 2750.C and Folio FT003. Use 5/16 locator pin on buggy "A". Check fit to Jig DT8150, ensure proper angle as per dwg			
3.0	QC5	INSPECT WORK TO CURRENT STEP	 <i>BT 09-04-14</i>
Comment: INSPECT WORK TO CURRENT STEP Inspect work to Step 6 Ensure fit to Jig DT8150			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	 <i>S on lot 14</i> <i>(FL8)</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>skid tube cell</u>			
<i>BT 09-04-15</i>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

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Seq. #: Machine Or Operation:

Description :

5.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/15 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

09-04-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>S</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
D1	01.04.17	ADD PART NUMBERS + DIE NUMBERS - <i>GP</i>	

RELEASED
 18.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
 TO ASTM STANDARD B221 BY AN APPROVED TESTING
 FACILITY TO ENSURE THAT THE BATCH MEETS THE
 ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

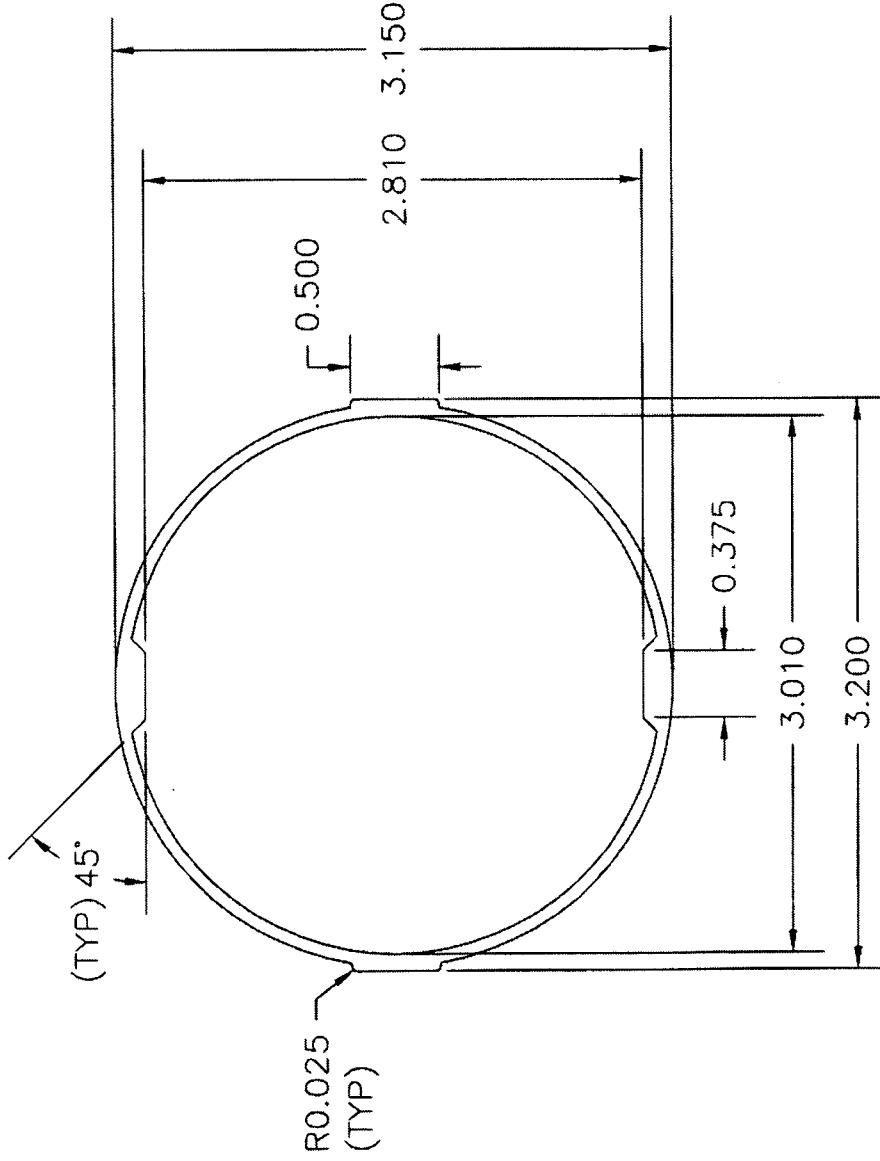
NOTE: Date & initial all entries

DART

DESIGN <i>DB</i>	DRAWN BY <i>JH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>JH</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED

98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

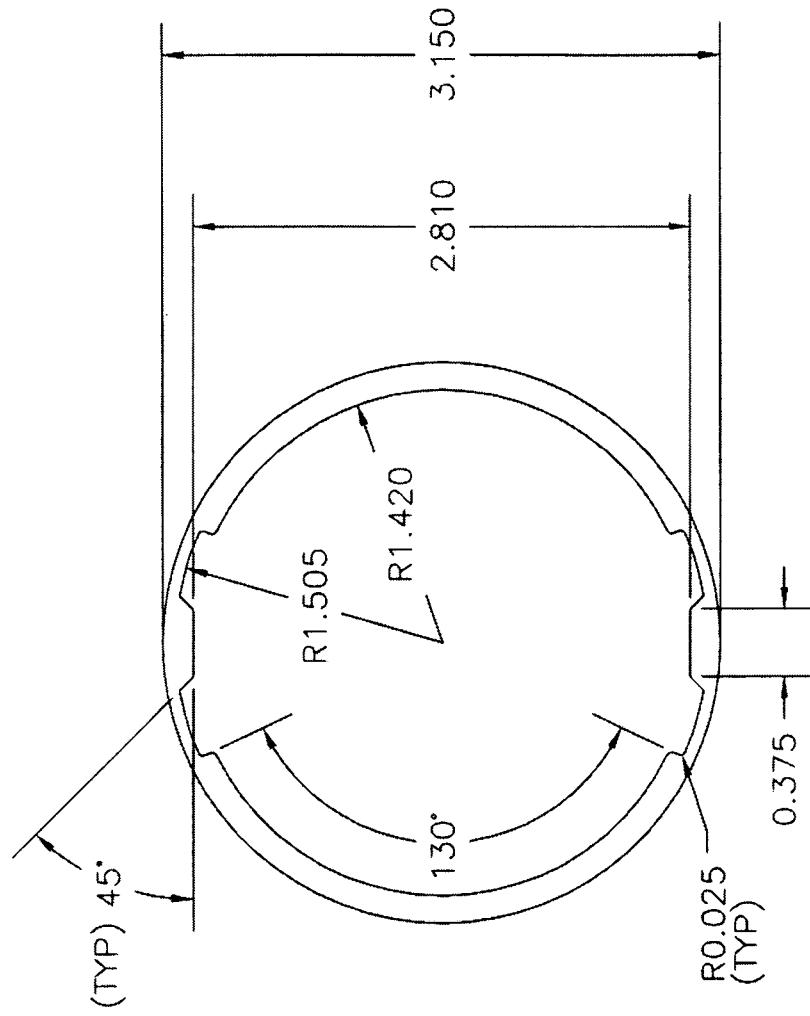
or FOR L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 V. 160" long)



DART

DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>GT</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

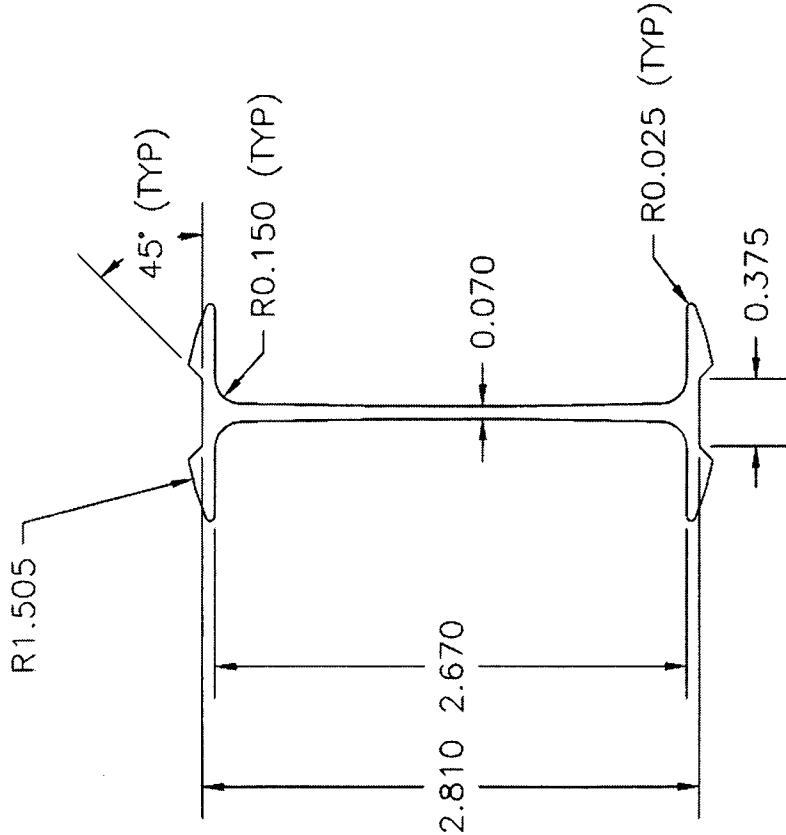
RELEASED
98.8.25 AS

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS PART LENGTH IN INCHES (E.G. D2600-3-120 IS 120" long)



DART

DESIGN <i>MP</i>	DRAWN BY <i>BB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>KE</i>	APPROVED <i>J</i>	DRAWING NO. D2600	REV. D	SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1	

RELEASED
98 8 25 DSD2600-5

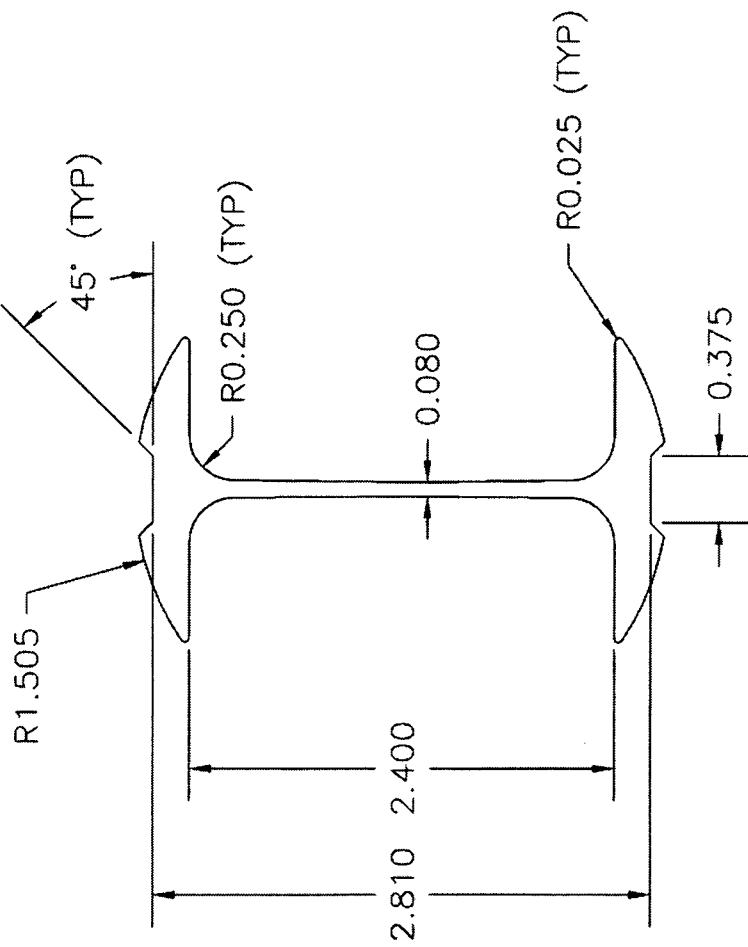
MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



DART

DESIGN <i>DK</i>	DRAWN BY <i>DS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DSD2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

